

Title (en)
Method of forming tooth grooves

Title (de)
Verfahren zur Herstellung von Zahnnuten

Title (fr)
Procédé pour la fabrication des rainures de dents

Publication
EP 1184122 B1 20050302 (EN)

Application
EP 01121111 A 20010903

Priority
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Abstract (en)
[origin: EP1184122A1] A cup-shaped grindstone (18) for grinding an end face of an annular portion (3) of a work (W) to form tooth grooves (4) in the end face includes a grinding portion (21) provided around an outer periphery of a disk portion. Abrasive grains of CBN are electrodeposited on each of first (21a), second (21b) and third (21c) grinding faces of the grinding portion. Cooling-liquid ejecting bores (21d) are provided in a lower end of the first grinding face (21a). To form the tooth grooves (4), the following steps are carried out: a rough-finish processing step cuts the tooth grooves (4) by intermittently feeding the cup-shaped grindstone (18) in a predetermined amount at a time, and a finish processing step of finishing the tooth grooves (4) by retaining the cup-shaped grindstone (18) at a predetermined position after the rough-finish processing step. During both steps, a cooling liquid is supplied from cooling-liquid ejecting bores (21d) defined in the first grinding faces (21a) of the cup-shaped grindstone (18).
<IMAGE>

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IPC 8 full level
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Cited by
CN106425305A; EP1440758A1; EP2650071A1; CN104220200A; EP2519755A4; RU2607062C2; US9518612B2; WO2011082240A1; US7052379B2; WO2013107339A1; WO2013152876A1

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